

SHIP JAN 15

Work Order ID 139737

139737

Page 1

Item ID: D350-607-541

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Quick Release Heli-Utility-Basket™ Long, HD Lid, Spacepod™/Squirrel Check Comp.

Start Date: 12/3/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/15/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Ship

Approvals:

Process Plan:

SW

Date:

20151203

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D350-607-3

D

DSI9699

A

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-607-541 CHG007

110

Pick Kit

0.00

110

Packaging

Memo

0.01

Packaging

JAN 11 2016

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

Work Order ID 139737

139737

Page 2

December 03, 2015 2:41:07 PM

Item ID: D350-607-541 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Quick Release Heli-Utility-Basket™ Long, HD Lid, Spacepod™/Squirrel Cheek Comp.
 Start Date: 12/3/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/15/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00				BAS			
Quality Control						21			
						9 03			
									JAN 12 2016
130	Pick Kit	0.00							
130									
Packaging	Memo	0.00							
Packaging	Package as per PPPD350-607-541								
									JAN 12 2016
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									JAN 12 2016

MLJ JAN 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 139737

139737

Parent Item: D350-607-541

D350-607-541

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, HD Lid, Spacepod™/Squirrel Cheek Comp.

Start Date: 12/3/2015

Required Date: 1/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10-08-19 AS PER REV.A DD VERF BY:EC IPP Rev:B
11.02.09 add to install label DD verf by:EC IPP REV:C 12.03.06
AS PER ECN12-535 DD VERF:EC IPP REV:D 12.07.24 AS PER
ECN 12-610 DD VERF:EC IPP REV:E 13.08.21 CHG005 / ECN 13-
624 DD VERF:JLM IPP REV:F 14.06.09 AS PER ECN14-572 DD
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-200		Manufactured	No			110	Each	11.0000	1	1			
D4086-200									**				
Placard, Max Load													DAS 6 28 9-89 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST078				11					
					138527			11					
D4917-300		Manufactured	No			110	Each	20.0000	1	1			
D4917-300									**				
Placard, Max Load													DAS 6 28 9-89 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST137				20					
					137895			8					
					138526			12					
D350-607-511		Manufactured	No			110	Each	2.0000	1	1			
D350-607-511									**				
Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH													DAS 6 28 9-89 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				PK015				1					
					136377			1					
				PK015A				1					
					136757			1					

B140467

JAN 11 2016

Picklist Print

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Page 2

Work Order ID: 139737

139737

Parent Item: D350-607-541

D350-607-541

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, HD Lid, Spacepod™/Squirrel Cheek Comp.

Start Date: 12/3/2015

Required Date: 1/15/2016

D2690-6 Manufactured No 110 Each 43.0000 Start Qty: 1.00 Required Qty: 1.00

D2690-6

Lanyard

**

DAS 6 28
9-89 9-89

Location Loc Qty Loc Code

ST009 28

137308 1

137431 27

ST012a 15

139060 15

D3912-041 Manufactured No 110 Each 7.0000

D3912-041

Eyebolt Receiver Assy

**

137065 DAS 6 28
9-89 9-89

Location Loc Qty Loc Code

ST057 7

133897 1

137879 6

D4030-041 Manufactured No 110 Each 0.0000

D4030-041

Long Basket Assembly (350)

**

139738 DAS 6 28
9-89 9-89

D4151-041 Manufactured No 110 Each 13.0000

D4151-041

Basket Fwd Hardpoint Assembly, Lower

**

Location Loc Qty Loc Code

ST088 5

137101 1

137620 4

ST090A 8

137887 8

DAS 6 28
9-89 9-89

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Shop Packet Print

Page 2

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Page 3

Work Order ID: 139737

139737

Parent Item: D350-607-541

D350-607-541

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, HD Lid, Spacepod™/Squirrel Cheek Comp.

Start Date: 12/3/2015

Required Date: 1/15/2016

D4151-043

Manufactured No

110 Each

Start Qty: 1.00
14.0000 1 1

Required Qty: 1.00

D4151-043

Basket Fwd Hardpoint Assembly, Upper

**

DAS
6
9-89
DAS
28
9-89

Location	Loc Qty	Loc Code
ST087	6	
136707	2	
136708	4	
137313	0	
ST090A	8	
137925	8	

D4150-041

Manufactured No

110 Each

5.0000 1 1

D4150-041

Attachment Arm Assembly

**

DAS
6
9-89
DAS
28
9-89
139545

Location	Loc Qty	Loc Code
ST085	2	
137193	2	
ST087	3	
137682	3	

AN4-13A

Purchased No

110 Each

20.0000 6 6

AN4-13A

Bolt

**

133769

Location	Loc Qty	Loc Code
FG	20	
122808	20	

DAS
6
9-89
DAS
28
9-89
JAN 11 2016

Picklist Print

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Work Order ID: 139737

139737

Parent Item: D350-607-541

D350-607-541

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, HD Lid, Spacepod™/Squirrel Cheek Comp.

Start Date: 12/3/2015

Required Date: 1/15/2016

AN4C15	Purchased	No	110	Each	42.0000	Start Qty: 1.00 1	1	Required Qty: 1.00	DAS 6 9-89	DAS 28 9-89
--------	-----------	----	-----	------	---------	----------------------	---	--------------------	------------------	-------------------

AN4C15
Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST312A	42	
M128936	7	
M133483	15	1
M133694	20	

AN310C4	Purchased	No	110	Each	81.0000	1	1	DAS 6 9-89	DAS 28 9-89
---------	-----------	----	-----	------	---------	---	---	------------------	-------------------

AN310C4
Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST331	81	
M131305	2	
M132344	4	
M133234	15	
M133483	40	1
M133694	20	

MS17984-C413	Purchased	No	110	Each	56.0000	1	1	DAS 6 9-89	DAS 28 9-89
--------------	-----------	----	-----	------	---------	---	---	------------------	-------------------

MS17984-C413
Quick Release Pin

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
CCK004	30	
m133577	10	
m133686	20	
ST315	26	
m133316	6	
m133483	20	1

Picklist Print

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Work Order ID: 139737

139737

Parent Item: D350-607-541

D350-607-541

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, HD Lid, Spacepod™/Squirrel Cheek Comp.

Start Date: 12/3/2015

Required Date: 1/15/2016

MS21042L4

Purchased

No

110

Each

Start Qty: 1.00
807.0000 6 6

Required Qty: 1.00

MS21042L 4

Locknut

**

133769

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

57

m127813

57

ST260a

138

m130799

56

m131803

6

m132262

76

ST303

441

m133363

441

ST305

169

m128300

8

m130388

7

m130922

97

m132123

56

m133316

1

MS24665-151

Purchased

No

110

Each

83.0000 1 1

MS24665-151

Cotter Pin

**

133769

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

59

m128401

59

ST289

24

m128401

6

m129909

18

Picklist Print

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Work Order ID: 139737

139737

Parent Item: D350-607-541

D350-607-541

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, HD Lid, Spacepod™/Squirrel Cheek Comp.

Start Date: 12/3/2015

Required Date: 1/15/2016

NAS1515H4L

Purchased

No

110

Each

291.0000

Start Qty: 1.00

2

2

Required Qty: 1.00

DAS

6

9-89

DAS

28

9-89

***NAS1515H4I ***

Washer

**

Location

Loc Qty

Loc Code

FG

22

103691

2

m132189

20

ST266

269

m132767

69

m133483

200

NAS1149F0432P

Purchased

No

110

Each

936.0000

12

12

DAS

6

9-89

DAS

28

9-89

NAS1149F0432P

WASHER

**

Location

Loc Qty

Loc Code

ST262

754

M132551

254

M133709

500

st268

182

M128995

57

M132677

125

NAS1149C0463R

Purchased

No

110

Each

259.0000

3

3

DAS

6

9-89

DAS

28

9-89

NAS1149C0463R

Washer

**

Location

Loc Qty

Loc Code

FP001

72

m127306

72

ST271

187

m128401

87

m133077

100

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 Rev.D,
INSTALLATION INSTRUCTIONS D350-607-4 Rev. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607 REV. 6
REF TCCA STC: SH94-14
REF FAA STC: SR00213NY
REF EASA STC: EASA.10016996
REF BRAZILIAN STC: 2007S03-03/-04/-05/-06

1.0 PURPOSE

This service instruction provides parts and instructions to facilitate installation of forward Basket Strut for customers that have purchased: D350-607-501 Conversion Kit @ CHG 004, D350-607-511 Quick Release Basket Mounting Kit @ CHG 004, D350-607-541 @ CHG 006, D350-607-543 @ CHG 007, D350-607-545 @ CHG 006, D350-607-547 @ CHG 007 Heli-Utility-Baskets as well as the D350-607-431 Strut Retrofit Kit and the D350-607-641 Long Cargo Tube @ CHG 001.

2.0 PARTS LIST:

Modify the quantities for D3910-5 and add D3910-7 as follows:

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET @ CHG 007 OR LATER
	X					D350-607-543	HELI-UTILITY-BASKET @ CHG 008 OR LATER
		X				D350-607-545	HELI-UTILITY-BASKET @ CHG 007 OR LATER
			X			D350-607-547	HELI-UTILITY-BASKET @ CHG 005 OR LATER
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
					X	D350-607-501	CONVERSION KIT @ CHG 005 OR LATER
				1	1	D3910-5	X-TUBE LUG
				1	1	D3910-7	X-TUBE LUG

(ADD)

QTY -413	QTY -415	QTY -417	QTY -419	QTY -431	PART NUMBER	DESCRIPTION
X					D350-607-413	HEAVY DUTY LID KIT (LONG)
	X				D350-607-415	HEAVY DUTY LID KIT (SHORT)
		X			D350-607-417	LIGHTWEIGHT LID KIT (LONG)
			X		D350-607-419	LIGHTWEIGHT LID KIT (SHORT)
				X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
				1	D3910-5	X-TUBE LUG
				1	D3910-7	X-TUBE LUG

(ADD)

QTY -641	QTY -611	QTY -511	QTY -431	PART NUMBER	DESCRIPTION
X				D350-607-641	QUICK RELEASE LONG CARGO TUBE
1	X			D350-607-611	LONG CARGO TUBE
1		X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
			X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
		1	1	D3910-5	X-TUBE LUG
		1	1	D3910-7	X-TUBE LUG

(ADD)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.05.16
CERT. NO.: SH94-14
ISSUE NO.: 6

20151203
SH 139737

A	NEW ISSUE	AJS	14.05.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	N/A	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9699	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LUG REPLACEMENT	NTS
DATE	14.05.16	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

3.0 PROCEDURE:

Install the D350-607-501 Conversion Kit, D350-607-511 Quick Release Mounting Kit or D350-607-431 Strut retrofit kit per Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C. While installing the Forward Strut perform the following:

- 3.1 Substitute the Forward Lower D3910-5 X-Tube Lug with the D3910-7 X-Tube Lug as shown in Figure 1.
- 3.2 Install the forward D4775-041 Strut Assembly. Transfer mark from the upper hole on the clevis of the D4775-041 Strut Assembly to the D3910-7 X-tube Lug and drill thru the lug $\varnothing 0.257$ - $\varnothing 0.261$ as shown in Figure 1. Touch up chemical conversion coating per MIL-DTL-5541. Check the witness holes located at the bottom end of the D4775-041 Strut Assemblies to ensure that the thread from the rod end extends past the witness hole.
Torque MS21042L4/-4 nuts to 50-70 in-lbs (5.7-7.9 N-m). Torque MS21042L6/-6 nuts to 160-190 in-lbs (18.1-21.5 N-m).
- 3.3 Complete the installation in accordance with Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C.

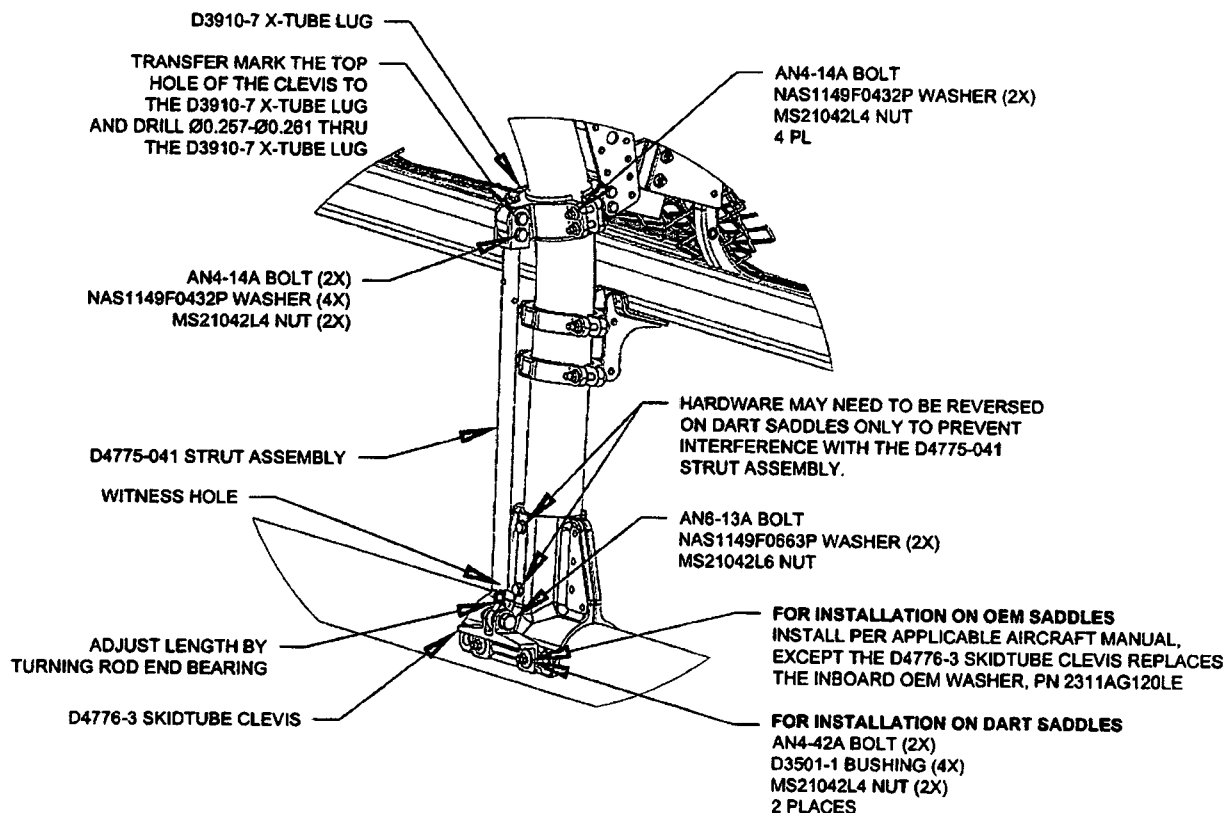


FIGURE 1: INSTALLATION OF D4775-041 FWD STRUT

4.0 WEIGHT AND BALANCE:

There is no weight and balance change associated with this update.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.05.16
CERT. NO.: SH94-14
ISSUE NO.: 6

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9699	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG REPLACEMENT	NTS
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